

Date: Tuesday, 4/17/2007 3:56:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP (CASTING DETAIL)
Job Number	: 31925		
Estimate Number	: 10510		
P.O. Number	: N/A	Part Number	: D25763
This Issue	: 4/17/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2576 REV. E1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29486	Drawing Revision	: E1
		Material	: N/A
		Due Date	: 5/5/2007
Written By	:	Qty:	100 Um: Each
Checked & Approved By	:		
Comment	: Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25761	Step (Casting Detail)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
1	D2576-1	Step (Casting Detail)	31940

J.L / J.F. 07/06/13 106

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS1

1- Machine as per Folio FA332 and Dwg D2576

2- Deburr

J.L / J.F. 07/06/13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L / J.F. 07/06/17

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07.06.21

5.0	PACKAGING.1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BARCLAY

07/06/21 (103)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D0576-3 PAR #: N/A Fault Category: Prod / Machine NCR: (Yes) No DQA: 28 Date: 07/06/22
 QA: N/C Closed: 18 Date: 07.06.22

NCR: <u>31925</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/18	2.0	3 parts are under .125" by 0.003" max at the center Aft welding location. R.C. cap was slightly lifted during machining.	<u>Q51042</u>	Parts acceptable. not Dimensions are not in a critical spot.	J.L. 07/06/19	<u>07/06/18</u>	<u>Q51042</u>	<u>07/06/18</u>
07/06/18	2.0	3 parts scrap. Parts pulled up to much, and have tool marks in them, and dimensions are too thin. .098 → .100.	<u>Q51042</u>	Scrap 3 parts & destroy.	J.L. 07/06/19	<u>07/06/18</u>	<u>Q51042</u>	<u>07/06/18</u>

NOTE: Date & initial all entries

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Drawing Name: STEP (CASTING DETAIL)

Job Number: 31925

Part Number: D25763

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



103

Comment: FINAL INSPECTION/W/O RELEASE

207/06/22

Job Completion



U 070622

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

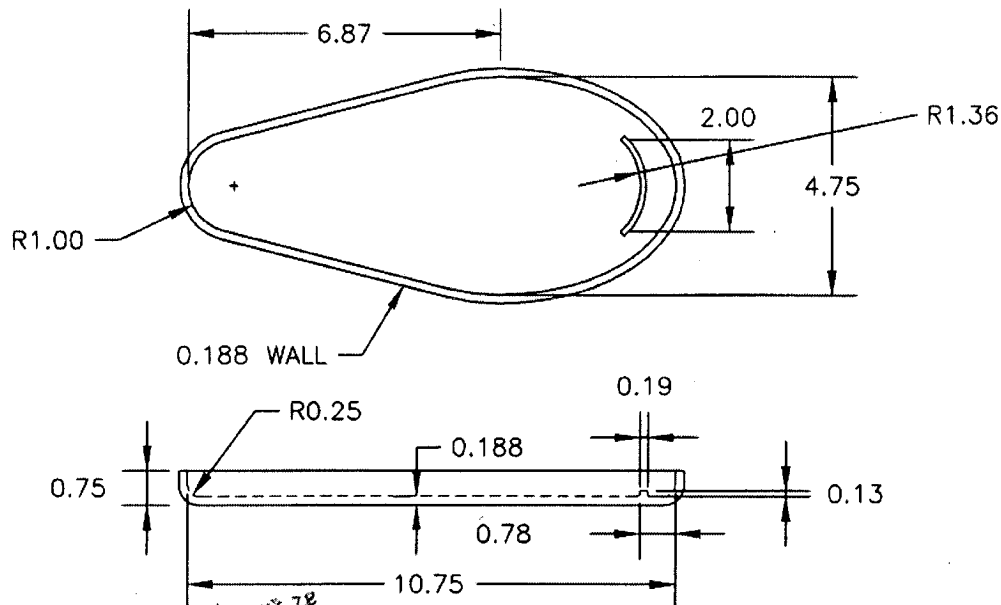


DESIGN 91	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 91	APPROVED KE	DRAWING NO. D2576	REV. E SHEET 1 OF 1
DATE 99.09.07		TITLE STEP	SCALE 1:4
A	96.09.18	NEW ISSUE	
B	96.11.28	REMOVE POCKETS, ADD HOLE	
C	98.08.18	ADD POCKETS & SLOTS FOR WELDING	
D	99.08.18	CHNG. SLOT SIZE AND LOC.(TSR A1069)	
E	99.09.07	CHNG. 0.50 HOLE LOC. AND ADD NOTE	
E1	RF 03.04.29	7.05 WAS 6.61	

RELEASED
99.09.08 DS

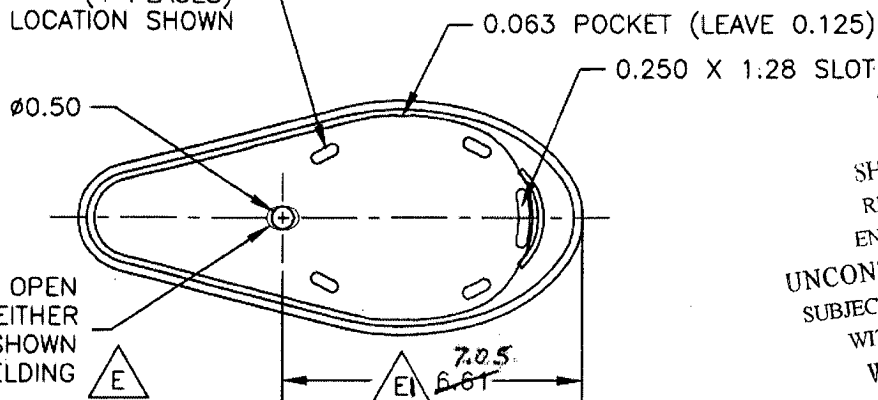
CASTING DETAIL (D2576-1) *08.28*
08.28

MATERIAL: CAST ALUMINUM ALLOY A-535.2
BREAK SHARP EDGES 0.025 TO 0.050
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



MACHINING DETAIL (D2576-3) *08.28*
08.28

$\triangle D$ 0.250 X 0.65 SLOT
(4 PLACES)
IN APPROX. LOCATION SHOWN



IT IS ACCEPTABLE TO OPEN
THIS HOLE 0.125 IN EITHER
DIRECTION AS SHOWN
FOR WELDING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31925